

Blue

Date: Wednesday, 03/09/2008 10:25:46 AM
 User: Julie Lecocq

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	206/OH-58 SADDLE, OUTBOARD, LEFT SIDE
Job Number	41712		Part Number	D29321
Estimate Number	10831		Drawing Number	D2932 REV C- BLUE
P.O. Number			Project Number	N/A
This Issue	03/09/2008	S.O. No. <i>1</i>	Drawing Revision	C
Prsht Rev.	NC	Type /MACHINED PARTS	Material	
First Issue	/ /		Due Date	26/09/2008
Previous Run	41128		Qty:	3
Written By			Um:	Each
Checked & Approved By	<i>JUL 08.9.03</i>			
Comment	Est: B 00.06.26 New DWG rev, (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101003	Saddle Billet, 7075	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s) 7075-T7351 2X6.25X7.875 Issue material from stock: 7075-T7351 Cut Size 2.0 x 6.25 X 7.880 Grain Along Long 7.88 Length Batch No: <i>B33712</i>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 5-Deburr & TUMBLE	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 10:25:46 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE

Job Number: 41712

Part Number: D29321

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F. 08/09/07 (3)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MF

08-09-08

(X3)

7.0 SPRAY PAINTING SPRAY PAINTING



Comment:

-PRIME

B 106729

-SPRAY PAINT DELFLEET BLUE

B 105918

-CLEAR DELFLEET

B 105917

ET 08-09-10 (3)

8.0 QC14 INSPECT SPRAY PAINT



08-09-11 (3)

Comment: INSPECT SPRAY PAINT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



(X3)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 403

09/12

S4

10.0 QC21 FINAL INSPECTION/W/O RELEASE



08/09/15 (3)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	L41712
Description: 206 Saddle, Outboard, Left side	Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.118	.117	.118			
B	0.100	0.140		.118	.115	.118			
C	0.100	0.140		.124	.124	.123			
D	0.210	0.230		.218	.219	.219			
E	1.245	1.255		1.250	1.250	1.250			
F	1.245	1.255		1.250	1.250	1.250			
G	2.495	2.505		2.500	2.500	2.500			
H	0.510	0.515		.510	.510	.510			
I	1.572	1.582		1.577	1.578	1.578			
J	2.495	2.505		2.500	2.500	2.500			
K	0.257	0.262		.258	.258	.258			
L	0.312	0.317		.318	.317	.317			
M	0.235	0.240		.238	.238	.238			
N	0.100	0.140		.122	.122	.122			
O	0.540	0.560		.545	.540	.545			
P	0.490	0.510		.505	.505	.505			
Q	3.715	3.725		3.720	3.720	3.720			
R	2.470	2.510		2.492	2.490	2.491			
S	0.240	0.270		.250	.250	.250			
T	0.100	0.180		.140	.140	.140			
U	1.625	1.635		1.630	1.630	1.630			
V	1.362	1.372		1.370	1.370	1.370			
W	0.316	0.321		.321	.321	.321			
X	1.125	1.145		1.137	1.135	1.135			
Y	1.565	1.585		1.571	1.570	1.570			
Z	0.178	0.198		.188	.188	.188			
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>JF</i>	Audited by:	<i>J-F.</i>
Date:	08/09/06	Date:	08/09/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>JF</i>	<i>JF</i>

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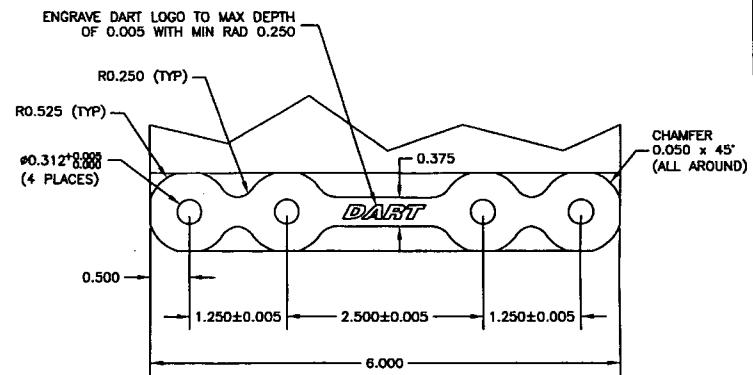
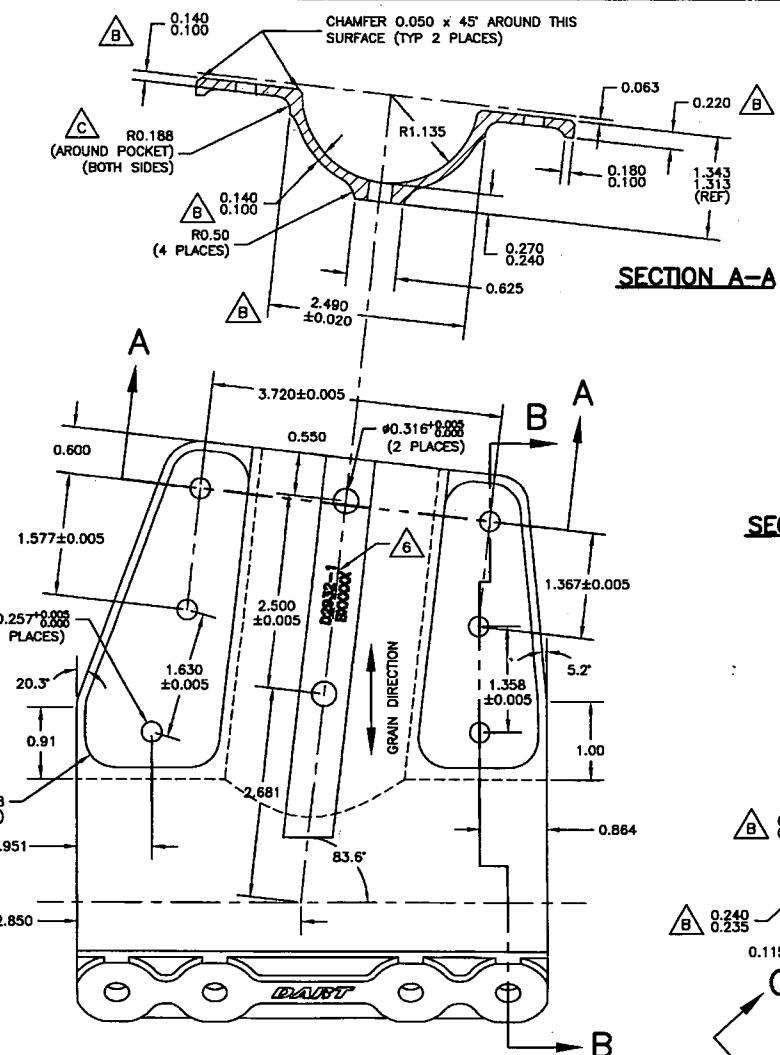
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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. *41712*



D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2932 REV. C SHEET 1 OF 1
DATE	TITLE	SCALE 06.11.09 SADDLE OUTSIDE 2-3

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